

Date: Friday, 21/07/2006 12:01:42 PM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LUG
Job Number :	27971		
Estimate Number :	11065		
P.O. Number :	N/A	Part Number :	D2944
This Issue :	21/07/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2944 REV A
First Issue :	N/A	Project Number :	N/A
Previous Run :	27971	Drawing Revision :	A
	Type :	Material :	N/A
	MACHINED PARTS	Due Date :	07/08/2006
Written By :			Qty: 20 Um: Each
Checked & Approved By :			
Comment :	Est B 04.01.21 Reformat; Added Step 6 KJ/RF Est. C 06.07.21 waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0187X04000	6061-T6 Bar .178" x 4.0"
-----	--------------------	--------------------------



Comment: Qty.: 0.2581 f(s)/Unit Total : 5.1618 f(s)
6061-T6 Bar .178" x 4.0"
Material: 6061-T6 (QQ-A-250/11) 0.188" thick
Identify for D2944

Batch: M19681

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D2944
Dwg Rev: A
Prog Rev: A

2-Deburr if necessary

SAD 06:08:08 20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:08:08

(20)

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

J.F. 06/08/09

(20)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: WAB

J.E. 06.08.09 20

Date: Friday, 21/07/2006 12:01:42 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 27971

Part Number: D2944

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/08/10 (20)

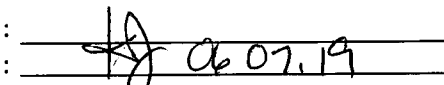

Job Completion



12 2008-10

Date: Tuesday, 7/18/2006 3:00:56 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LUG
Job Number :	27971		
Estimate Number :	11065		
P.O. Number :		Part Number :	D2944
This Issue :	7/18/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2944 REV A
First Issue :	//	Project Number :	N/A
Previous Run :		Drawing Revision :	A
	Type :	Material :	
	MACHINED PARTS	Due Date :	8/7/2006
Written By :		Qty:	20
Checked & Approved By :		Um:	Each
Comment :	Est B 04.04.21 Reformat; Added Step 6 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0187X04000	6061-T6 Bar .178" x 4.0"
-----	--------------------	--------------------------



Comment: Qty.: 0.2581 f(s)/Unit Total : 5.1618 f(s)

6061-T6 Bar .178" x 4.0"

Material: 6061-T6 (QQ-A-250/11) 0.188" thick

Identify for D2944

Batch: _____

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

1) Blank makes (2) D2944

Cut blank: 4.00" x 5.900" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA024 and Dwg D2944

Identify as D2944

Tumble and Deburr any rough edges after tumbling.

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/18/2006 3:00:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 27971

Part Number: D2944

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

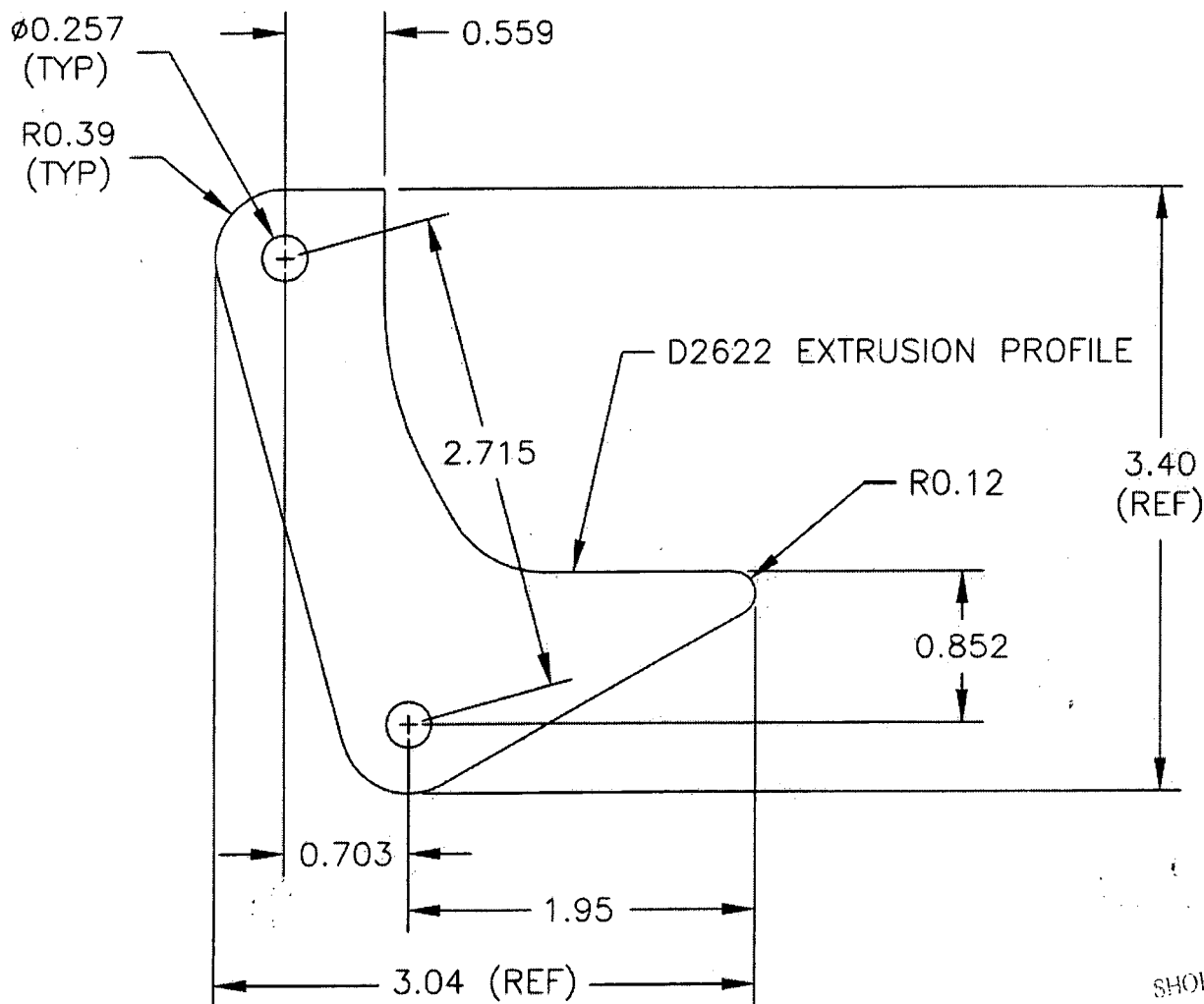
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2944	REV. A SHEET 1 OF 1
DATE 99.12.13		TITLE STEP MOUNTING PLATE	SCALE 1:1
A	99.12.13	NEW ISSUE	

RELEASED
99.12.21 DS



MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK
BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27971